

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016353**Date Inspected:** 08-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Qiu Wen		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no.10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057259 perform SMAW welding on; South shaft, Lift 5, intersection diaphragm plate to inside Skin C and the weld joint is identified as SSD1-TL5-1 B/F-12. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-P5. (Photo attached)

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW welding on; South shaft, Lift 5, intersection diaphragm plate to Grillage plate and the weld joint is identified as SSD1-TL5-1 E/F-1B. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 067993 perform SMAW welding on; North shaft, Lift 5, intersection diaphragm plate to Grillage plate and the weld joint is identified as NSD1-TL5-3 F/F-2. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-P5.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052075 perform FCAW welding on; Façade plate Base plate and the Façade plate is identified as SFSA4-327-135 mtr.. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair. (Photo attached)

Bay no. 11

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046709 perform SMAW welding on; East shaft, Lift 5, intersection diaphragm plate to Grillage plate and the weld joint is identified as ESD1-TL5-2 E/F-12B. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 perform SMAW welding on; East shaft, Lift 5, intersection diaphragm plate to Grillage plate and the weld joint is identified as ESD1-TL5-2 E/F-22. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4C.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as OBG Side panel plate (Notification no. 06358), OBG Side plate and Bike path (Notification no. 06361) and OBG Bike path and Edge plate (Notification no. 06354) The weld designations reviewed are as follows:

SP 3070-001 - Jt. nos – 62,64,70,71 –Side panel

SP 3107-001 - Jt. nos – 71,51,81,85,86,87,88,90,95 –Side panel

BK 004A1-017 - Jt. no – 009 –OBG Bike path

EP 3023A-001 - Jt. nos – 19,20,23,24,3,5 –Edge panel

EP 3016A-001 - Jt. nos – 28,29,11,12,9,10 –Edge panel

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

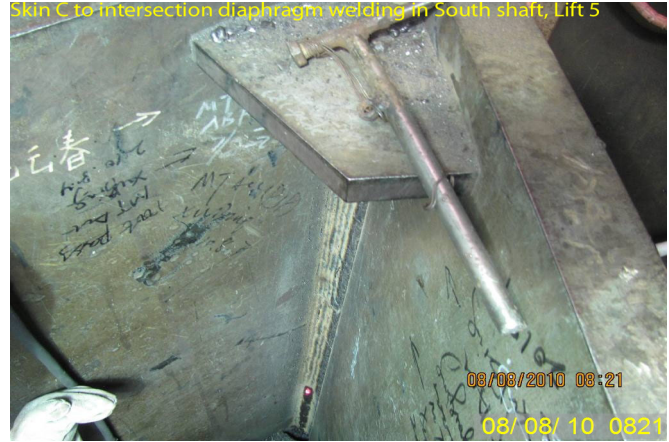
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Facade plate Base build up welding at Bay no. 10



Skin C to intersection diaphragm welding in South shaft, Lift 5



Summary of Conversations:

This QA Inspector, asked Mr. Steve Hall for the wrapping off welding in diaphragm plates inbetween stiffeners of OBG Lift 13, Side panel plate no. SP3070-001, which was wrapped off. As per Mr. Steve hall, this is an outstanding issue and need solution from Mr. Eric Sang. Since Mr. Eric sang not available today, this will be sorted out tomorrow.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar,Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer